

# Work Order ID 75910

November-02-11 10:11:15 AM

\*75910\*

~~U/R~~

Page 1

Item ID: D412-742-043

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Replacement Float Skidtube

Start Date: 01/11/2011 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 15/11/2011 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: M.L. J

Date: 11/11/07 Tooling:

Date:

Run Start

\*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3391	H U/R <u>CP 11.11.07</u>

100 0.00

\*100\*

DC

Document Control

DOCUMENT CONTROL

Memo

0.00

If D412-742-043 is a W/O on it's own,  
Photocopy bluefile and create labels per PPP D412-742-043 CHG004

CHG 005

CP 11.11.08

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 75910****\*75910\***

Page 2

November-02-11 10:11:15 AM

Item ID: D412-742-043

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Float Skidtube

Start Date: 01/11/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 15/11/2011 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

0.00

**\*110\***

HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.  
A/RSikaflex-241/-291 11119443  
Expiry date: 12/01

2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube, hand tighten only bolts with no sikaflex.

A/RSikaflex-241/-291 11119443  
Expiry date: 12/01

3-Remove "T" pins once sikaflex is dry.

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.  
A/RLPS Procyon 11114596

1 ~~2~~ 11 12/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 75910****\*75910\***

Page 3

November-02-11 10:11:15 AM

Item ID: D412-742-043

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Float Skidtube

Start Date: 01/11/2011 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 15/11/2011 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC5- Inspect part completeness to step on W/O 0.00

**\*120\***

QC

Memo

0.00

Quality Control

130

**\*130\***

Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D412-742-043

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

0.00

0.00

140

**\*140\***

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

MF  
12-01-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

November-02-11 10:11:19 AM

Page 1

Work Order ID: 75910

\*75910\*

Parent Item: D412-742-043

\*D412-742-043\*

Parent Item Name: Replacement Float Skidtube

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

## Comments:

IPP Rev A 05.10.13 New Issue KJ/JLM  
 IPP Rev 06.02.13 ECN 773 dwg @ rev.D EC  
 IPP Rev:C 07-05-28 As per Rev F JLM  
 IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM  
 IPP Rev:E 08-09-08 ecn 08-510 DD verified by:EC IPP Rev:F  
 11.11.01 as per DSI9517 REV.B DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C4A		Purchased	No			110	Each	2,389.000	24	24			

\*AN3C4A\*

BOLT

\*\*

ju 11/12/21

Location	Loc Qty	Loc Code
ST350	2389	
117313	2	
117688	5	
117872	22	
118112	16	
118451	2	
118706	364	
118838	978	
119328	1000	

x24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Page 2

Work Order ID: 75910

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

\*75910\*

\*D412-742-043\*

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C6A Purchased No 110 Each 276.0000 10 **\*\*** 1119749 (vs8) MU 11/12/11 \*PTO=

\*AN3C6A\*  
BOLT

Location	Loc Qty	Loc Code
FP-A	1	
111982	1	
ST350	100	
119449	100	
ST351	175	
111982	2	
116419	23	
116549	2	
116704	12	
117619	10	
117688	1	
117872	5	
118422	120	

AN3C7A Purchased No 110 Each 131.0000 4 **\*\*** 4 1119749 (vs8) MU 11/12/11

\*AN3C7A\*  
BOLT

Location	Loc Qty	Loc Code
ST351	131	
113149	14	
116169	1	
117313	10	
117619	12	
117688	18	
118422	76	

AN960C10L ~~NAS1149C0332~~ Purchased No 110 Each 0.0000 38 **\*\*** 38 1119736 (vs8) MU 11/12/11

\*AN960C10I \*  
washer

November-02-11 10:11:19 AM

Shop Packet Print

Page 2

W/O: 75910		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/12/21	110	Replace (2x) AN3C-6A bolts with (2x) AN3C-5A / 111197-14 bolts for proper fit.	HL	11/12/21	x2		

Part No: D412-742-043 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

November-02-11 10:11:19 AM

Page 3

Work Order ID: 75910

**\*75910\***

Parent Item: D412-742-043

**\*D412-742-043\***

Parent Item Name: Replacement Float Skidtube

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3391-021

**\*D3391-021\***

Fwd Tube Assembly

D3391-023

**\*D3391-023\***

Mid Tube Assembly

D3391-025

**\*D3391-025\***

Aft Tube Assembly

D3564-5

**\*D3564-5\***

Wearshoe

Manufactured

No

110

Each

0.0000

1

1

\*\*

*B71457 (x1) M u12/21*

Manufactured

No

110

Each

0.0000

1

1

\*\*

*B75955 (x1) M u12/21*

Manufactured

No

110

Each

0.0000

1

1

\*\*

*B76394 (x1) M u12/21*

Manufactured

No

110

Each

14.0000

1

1

\*\*

*B77737 (x1) M u12/23*

Location

Loc Qty

Loc Code

FG

2

34806

2

FP19

12

73330

12

D3566-5

**\*D3566-5\***

Gasket

Manufactured

No

110

Each

34.0000

1

1

\*\*

*N/A*

Location

Loc Qty

Loc Code

FP002

34

74387

12

75069

22

D4095-041

**\*D4095-041\***

Wearplate Assembly

Manufactured

No

110

Each

10.0000

1

1

\*\*

*D4095-041 (x1) M u12/21*  
*76534*

Location

Loc Qty

Loc Code

ST

10

74852

10

November-02-11 10:11:19 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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November-02-11 10:11:19 AM

Page 4

Work Order ID: 75910

\*75910\*

Parent Item: D412-742-043

\*D412-742-043\*

Parent Item Name: Replacement Float Skidtube

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

D4095-043

Manufactured No

110

Each

10.0000

1

1

\*D4095-043\*

Wearplate Assembly

\*\*

B76535 (v1) H. 12/21

Location

Loc Qty

Loc Code

ST

10

74853

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

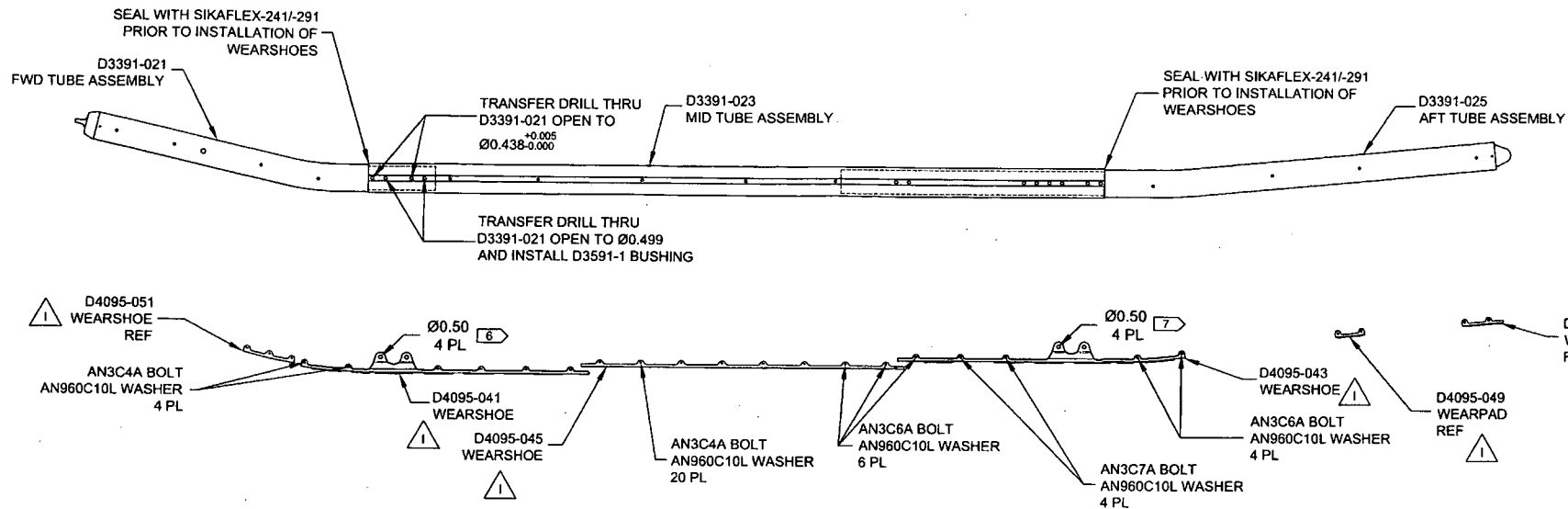
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





#### D3391-043 ASSEMBLY

#### D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY -043	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARSHOE
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

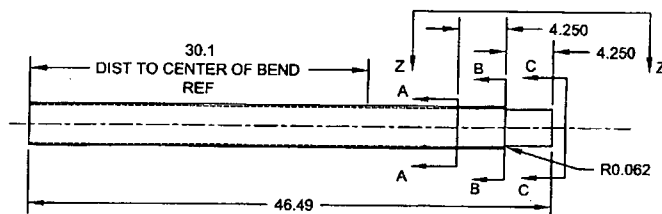
#### GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"  
AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 0.297 SIZE HOLES  
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT  
WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH  
APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND  
TRANSFER DRILL 0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH  
THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND  
TRANSFER DRILL 0.50 HOLES FROM SADDLE TO D4095-043

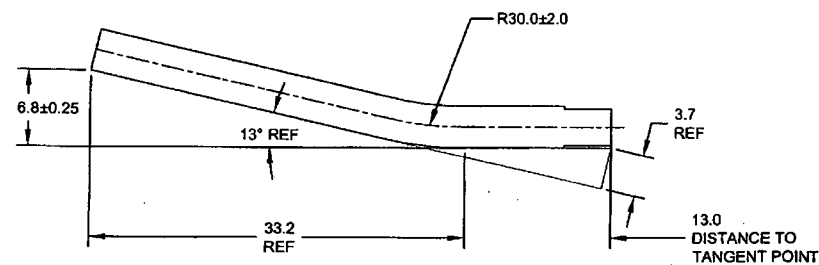
RELEASED  
2011-11-04

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D3391	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

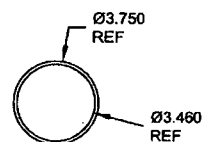




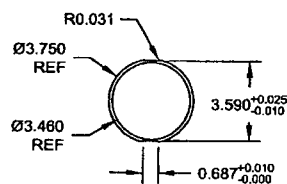
**D3391-1 CUTTING DETAIL**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



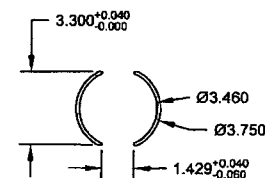
**D3391-011/-021 BENDING DETAIL**  
(MAKE FROM D3391-1)



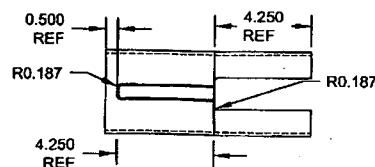
**SECTION A-A**  
SCALE 2X



**SECTION B-B**  
SCALE 2X



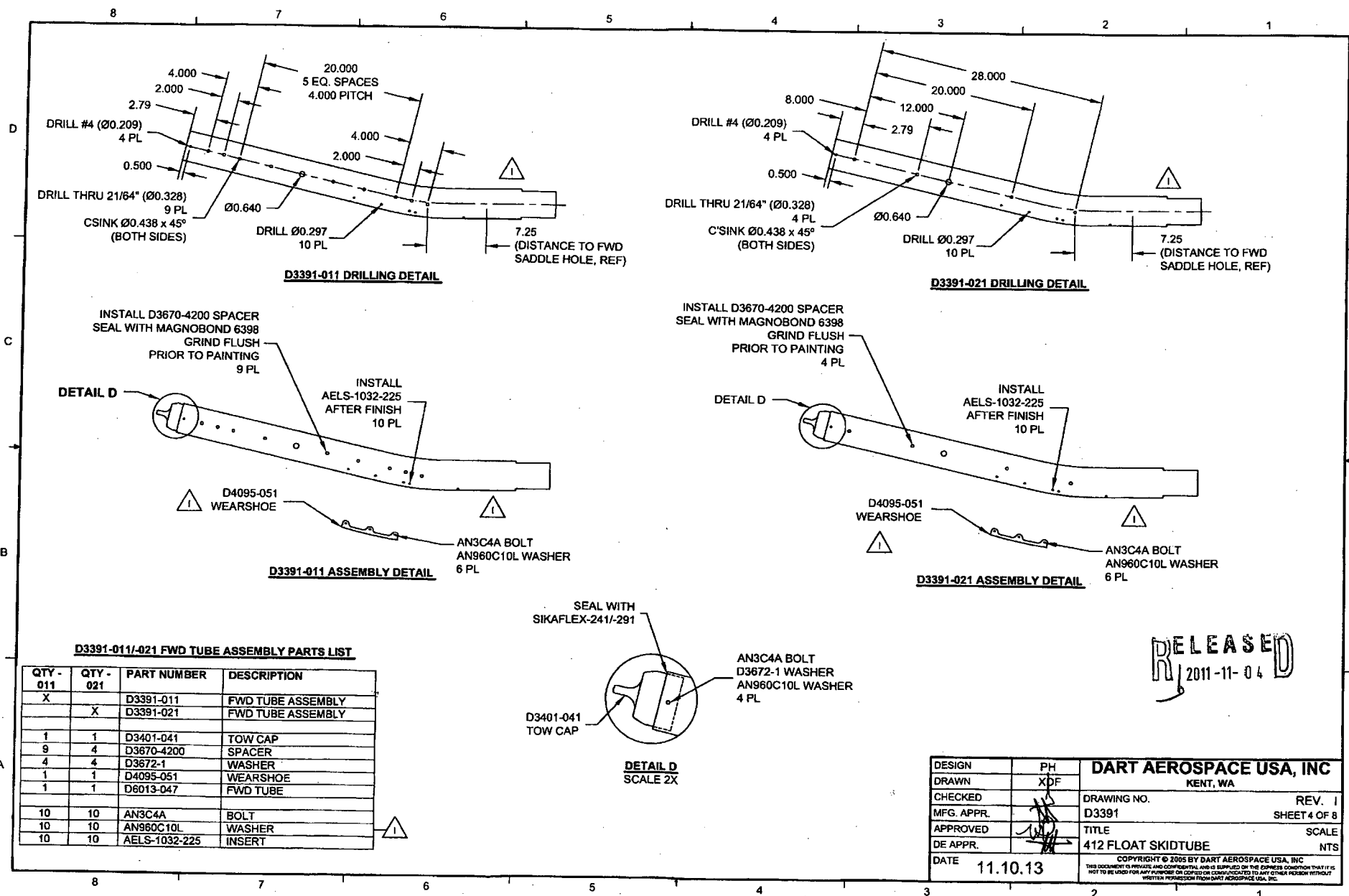
**SECTION C-C**  
SCALE 2X



**VIEW Z-Z**  
SCALE 2X

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2011-11-04

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO. D3391	REV. 1
MFG. APPR.			SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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2011-11-04

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DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO. D3391	REV. 1 SHEET 4 OF 8
MFG. APPR.		TITLE 412 FLOAT SKIDTUBE	SCALE NTS
APPROVED		DATE 11.10.13	
DE APPR.		COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

D

D

C

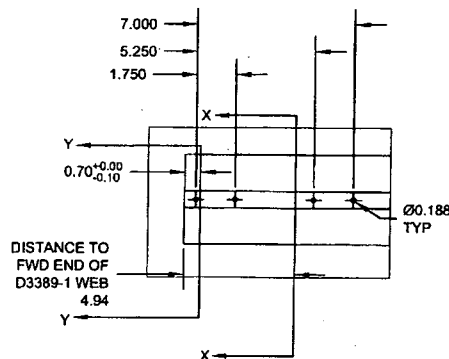
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B

B

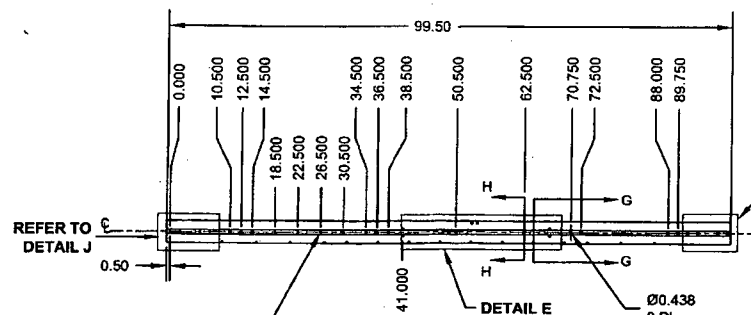
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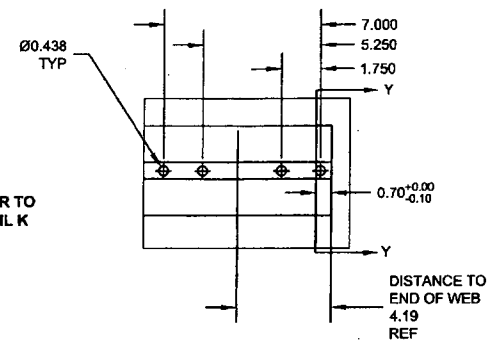
DETAIL J  
SCALE 4X

DRILL THRU 21/64" (Ø0.328)  
CSINK Ø0.438 X 45° (BOTH SIDES)  
12 PL



D3391-013 ASSEMBLY DETAIL

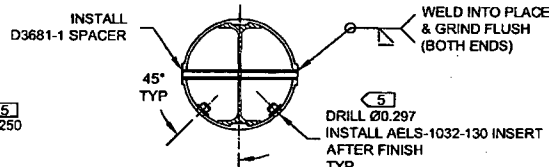
REFER TO  
DETAIL K



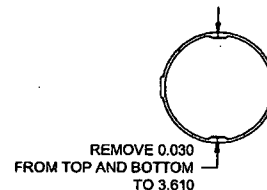
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SCALE 4X



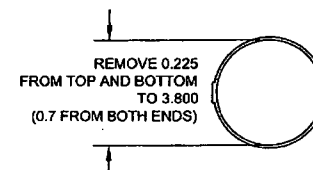
SECTION G-G  
SCALE 5X



SECTION H-H  
SCALE 5X



SECTION X-X  
SCALE 5X



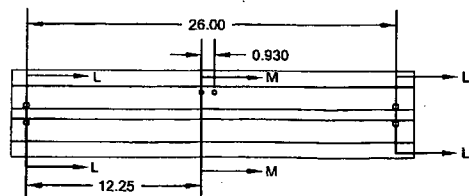
SECTION Y-Y  
SCALE 5X

D3391-013 MID TUBE ASSEMBLY PARTS LIST

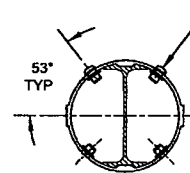
QTY	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

D3391-013 MID TUBE ASSEMBLY

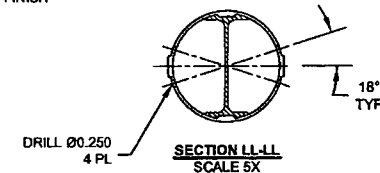
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004



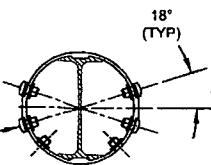
DETAIL E  
SCALE NONE



SECTION M-M  
SCALE 5X



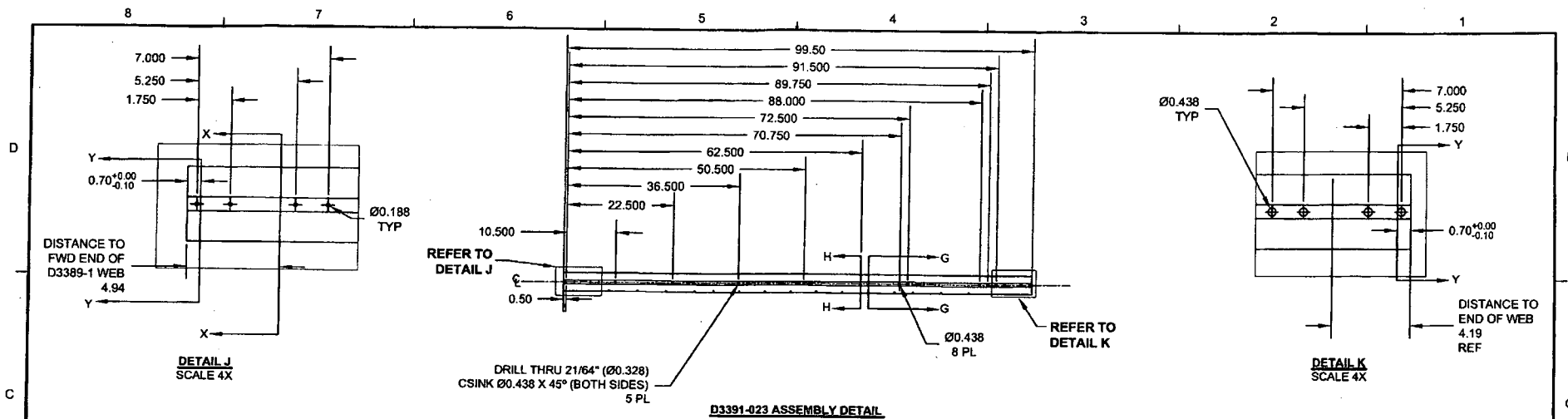
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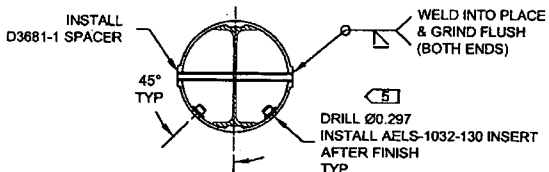
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SCALE 5X

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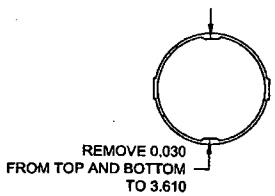
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. I
MFG. APPR.		D3391	SHEET 5 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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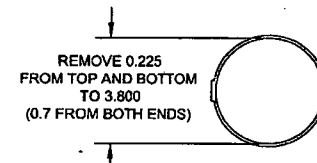
SECTION G-G  
SCALE 5X



SECTION H-H  
SCALE 5X



SECTION X-X  
SCALE 5X



SECTION Y-Y  
SCALE 5X

**D3391-023 MID TUBE ASSEMBLY PARTS LIST**

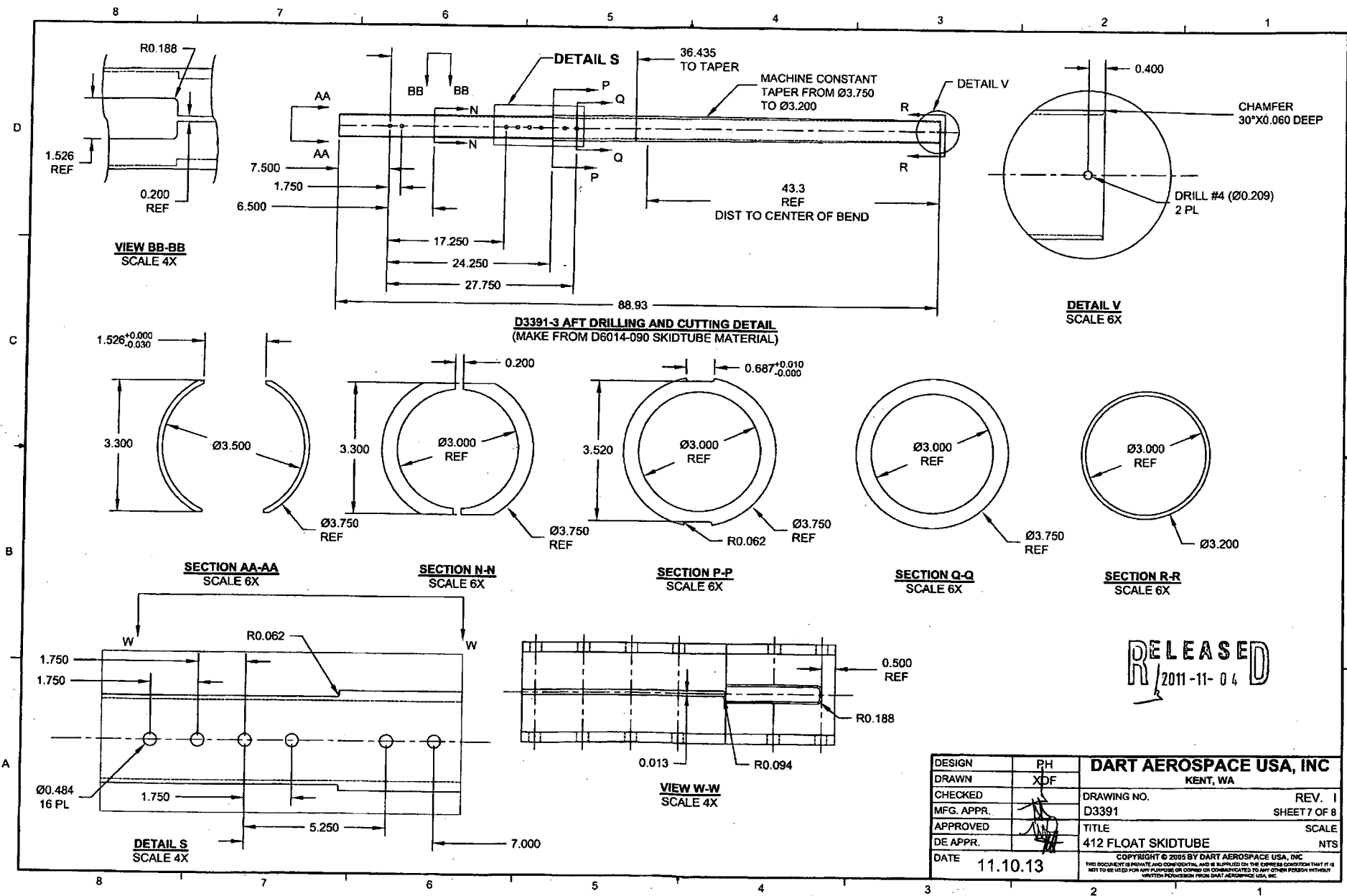
QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

**D3391-023 MID TUBE ASSEMBLY**

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004

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